DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018650
Date Inspected: 21-Oct-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1500
OSM Departure Time: 300
Location: ShangHai, China

CWI Name:	Tian Lei			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1
This QA Inspector observed the following work in progress for Bay 1.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhu Lin.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Barrier Rail
PCMK: E2-SB5-019
Welder: 059450
WPS-B-T-2132-3

Heat straightening of PCMK, E2-SB1-009, under approved Heat Straightening procedure, HSR 1(B)-9389, 20TR2-049 with HSR (B)-362, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhu Lin. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 13mm.

Bay 2
This QA Inspector observed the following work in progress for Bay 2.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhu Lin.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam
PCMK: FB3325-001-023~026
Welder: 201583
WPS-B-T-2132-3

PCMK: FB3343-001-244
Welder: 045227
WPS-B-T-2233-TC-U5-F

PCMK: FB3343-001-279
Welder: 045240
WPS-B-T-2233-TC-U5-F

Heat straightening of PCMK, SA3400-001, under approved Heat Straightening procedure, HSR (B)-430, FB3328-001 with HSR (B)-429, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhu Lin. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 45mm and 60mm.

Bay 3
This QA Inspector observed the following work in progress for Bay 3.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhang Ya Xu.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam
PCMK: FB3286-001-027
Welder: 055491
WPS-B-T-2232-TC-U5-F

PCMK: FB3286-001-048
Welder: 044830
WPS-B-T-2132-3

PCMK: FB3286-001-062
Welder: 050242

WPS-B-T-2132-3

PCMK: FB3286-001-155
Welder: 055564
WPS-B-T-2132-3

Heat straightening of PCMK, SA3359-001-001, under approved Heat Straightening procedure, HSR 1(B)-9650, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhang Ya Xu. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 45mm and 60mm.

Bay 4
This QA Inspector observed the following work in progress for Bay 4.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhang Ya Xu.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

PCMK: SA3359-001-001
Welder: 206623
Report: B-WR16081
WPS-345-FCAW-1G (1F)-Repair-1

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; SA3358, SA3360, SA3362, SA3364 for item number 1 on NWIT tracker document # 07056.

Bay 6
This QA Inspector observed the following work in progress for Bay 6.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Huang Min.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Cross Beam
PCMK: CB3002L-018-112
Welder: 048625
WPS-B-T-2233-TC-P4-F

PCMK: CB3002L-018-136
Welder: 053742
WPS-B-T-2233-TC-P5-F

PCMK: CB3002L-018-092
Welder: 205386
WPS-B-T-2233-TC-P5-F

PCMK: CB3002L-018-073
Welder: 051246
WPS-B-T-2233-TC-P5-F

PCMK: CB3002L-018-046
Welder: 053609
WPS-B-T-2233-TC-P5-F

Bay 7
This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wang Liang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Barrier Rail
PCMK: W2-SB9-024-51~56
Welder: 062447
WPS-B-T-2132-3

PCMK: W2-SB9-025-116~121
Welder: 215689
WPS-B-T-2132-3

Bay 8
This QA Inspector observed the following work in progress for Bay 8.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wang Liang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Bike Path
PCMK: BK004A6-053-050
Welder: 500479
WPS-B-T-2132

Bay 10
ZPMC perform grinding work on BK004-007.

Bay 11
ZPMC perform grinding work on West Jacking Frame.

Blasting Shop # 2
QA inspector has performed visual inspection on interior of elevation 99 meter to top end of
Tower Lift # 3-North Side

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
No relevant conversations
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer